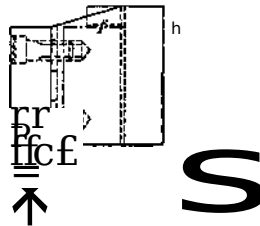


the bottom plate, three out of the four bushings will be located in the top part, and when using a multiple-spindle drill, the face *R* will take the greater thrust, which is better than to place the thrust on the binding screws /. In the designs in Figs. 4 and 5 the whole top and bottom face of the jig must be finished, or a strip marked/in Fig. 6, at both ends of the top and bottom surfaces, must be provided, so that it can be finished, and the jig placed on parallels *D* as illustrated.

While the jig itself, developed so far, possesses most of the necessary points for rapid production and accurate work, the



**Fig. 5. Alternative
Design of Jig shown in Fig. 4**

use of parallels, as indicated in Fig. 6, for supporting the jig when turned over so that the screw-heads of the clamping screws point downward, is unsatisfactory. Therefore, by adding feet to the jig, as shown in Fig. 7, the handling of the jig will be a great deal more convenient. The adding of the protruding handle 5* will still further increase the

convenience of using the jig. The design in Fig. 7 also presents an improvement over that in Fig. 4, in that, besides the adding of feet and handle, the leaf or strap *E* is used for holding screw *Q* instead of the arm *P*. This latter is more apt to bend if not very heavy, and would then bring the set-screw in an angle upwards, which would have a tendency to tilt the work. The strap can be more safely relied upon to clamp the work squarely. Two set-screws / are shown, for holding the work in place. The number of these set-screws,